

Date: Monday, 07/07/2008 11:49:20 AM
 User: Julie Lecocq

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CABIN DOOR ROLLER KIT RH
 Job Number : 40328
 Estimate Number : 13449
 P.O. Number :
 This Issue : 07/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 07/07/2008 Type : SMALL /MED FAB
 Previous Run :
 Part Number : D412698032
 Drawing Number : IIN D412-698 REV E
 Project Number : N/A
 Drawing Revision : E
 Material :
 Due Date : 30/07/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : JLD 08.7.07
 Comment : Est Rev:A New Issue 08.07.03 EC verified by:LL

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



S 08/10/06



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-698-032 CHG001

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D3121144 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) (2)

Bracket Assembly

batch: B39963

B40344

SP

4.0 D3137043 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bracket Assembly

batch: B29725

SP

5.0 D3183044 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) (3)

Bracket Assembly

batch: B40251

B40158

8/9/3

(4X)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 11:49:20 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN DOOR ROLLER KIT RH

Job Number: 40328

Part Number: D412698032

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

D32023

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cover

batch: B40345

8/9/3

scf

4x

7.0

D3674041

BRACKET ASSEMBLY



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

BRACKET ASSEMBLY

batch: B40122

3X

8/9/6

1

8.0

D36751

SLIDING DOOR BRACKET



Comment: Qty.: 9.0000 Each(s)/Unit Total : 36.0000 Each(s)

SLIDING DOOR BRACKET

batch: B40347

8/9/6

1

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

508/10/06

40

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-031

Location:

PPP Rev: PRFT

8/9/6

1

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/06

Job Completion



08/10/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Part Number	Description
X						D412-698-019	BEARING OVERHAUL KIT
	X					D412-698-021	REPLACEMENT SHIM KIT
		X				D412-698-031	CABIN DOOR ROLLER KIT, LH
			X			D412-698-032	CABIN DOOR ROLLER KIT, RH
				X		D412-698-033	REPLACEMENT DOOR TRACK KIT
					X	D412-698-035	DOOR HANDLE KIT
7						D3121-21	BOLT
5						D3121-241	BEARING ASSEMBLY
1						D3137-3	GUIDE
1						D3137-5	WASHER
2						D3183-045	BEARING ASSEMBLY
	3					D3238-1	SHIM
	1					D3238-3	SHIM
	2					D3238-5	SHIM
	6					D3238-11	SHIM
	2					D3238-13	SHIM
	4					D3238-15	SHIM
		1				D3121-143	BRACKET ASSEMBLY
			1			D3121-144	BRACKET ASSEMBLY
		1	1			D3137-043	BRACKET ASSEMBLY
		1				D3183-043	BRACKET ASSEMBLY
			1			D3183-044	BRACKET ASSEMBLY
		1	1	1		D3202-3	COVER
		3	3			D3674-041	BRACKET ASSEMBLY
		9	9	9		D3675-1	BRACKET
					2	D3779-041	HANDLE ASSEMBLY
					2	D3779-3	PLATE
					2	D3779-043	HANDLE ASSEMBLY
					12	AN525-832R8	SCREW
					12	AN960JD10L	WASHER
					12	MS21042L3	NUT
					12	MS24694-S58	SCREW
1						MS24694-S101	SCREW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40328

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Revision: E
Date: 08.05.01

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